

# Work Order ID 50513

July 13, 2009 10:20:59 AM



Page 1

Item ID: D2855

Accept

Revision ID: A

Setup Start

Item Name: Cap

Stop

Start Date: 7/13/09

Start Qty: 50.00



Required Date: 7/20/09

Req'd Qty: 30.00



Cust Item ID:

Customer:

## Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop



QC:

Date:

SPC (Y/N):

Date:



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

100



PURCHASING

0.00

CL 09/07/13

50

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10084  
Required

Cast per Dwg D2855 Material Release Note

110



Receive & Inspect for Damage & Mat'l Certs

0.00

PGH/127 (62)

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120



QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

⇒ 5010728

center  
52

f

# Work Order ID 50513

July 13, 2009 10:20:59 AM



Page 2

Item ID: D2855

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 7/13/09 Start Qty: 30.00



Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 30.00



Customer:

## Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

130



Small Fab

Operation  
Description

Small Fab

Memo

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Small Fab

1- Drill as per Dwg D2855 using DT8235 2- Open holes to 19/64" 3- Deburr

*EP09/07/29 52*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*25 09/07/09*

*09/07/09  
452*

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 9:30AM OVEN TEMPERATURE:  
FINISH TIME: 10:00AM 320°F

*09-07-29 452*

*PA112140*

# Work Order ID 50513

July 13, 2009 10:20:59 AM



Page 3

Item ID: D2855

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 7/13/09 Start Qty: 30.00



Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 30.00



Customer:

## Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC3- Inspect Part Finish

Set Up/  
Run Hours

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

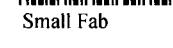
52

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170



Small Fab

Small Fab

Small Fab

0.00

0.00

BR 09-07-29.

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

52

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

=> S 09/07/09

count to  
652

f

**Work Order ID 50513**

July 13, 2009 10:20:59 AM



Page 4

Item ID: D2855

Accept

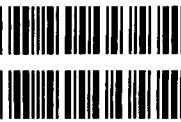


Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 7/13/09 Start Qty: 30.00



Cust Item ID:

Required Date: 7/20/09 Req'd Qty: 30.00



Customer:

**Reference:**

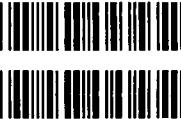
Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID**

190



Packaging

Packaging

**Operation  
Description**

Identify as per dwg &amp; Stock Location:

FP-6

**Set Up/  
Run Hours**

0.00

**Draw  
Number**

BL

**Draw  
Rev.**

090729

**Plan  
Code**

62

**Accept  
Qty**

00

**Reject  
Qty**

00

**Reject  
Number****Insp.  
Stamp**

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

09/07/29 J

Memo

0.00

MF 09-07-29

# Picklist Print

July 13, 2009 10:20:59 AM

Page 1

Work Order ID: 50513



Parent Item: D2855RevA



Parent Item Name: Cap

Start Date: 7/13/09

Required Date: 7/20/09

Comments:

Start Qty: 30.00

Required Qty: 30.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	877.0000	104	60.0000		

X INSERT

Warehouse      Loc Qty      Loc Code

Location

Main Warehouse

X M 107C8

ST

877

1st # BR 09-07-29.

100895	21
100896	102
102018	102
110118	52
111529	300
111581	300

D2855PRevA

Purchased

No

170

Each

0.0000

30.0000



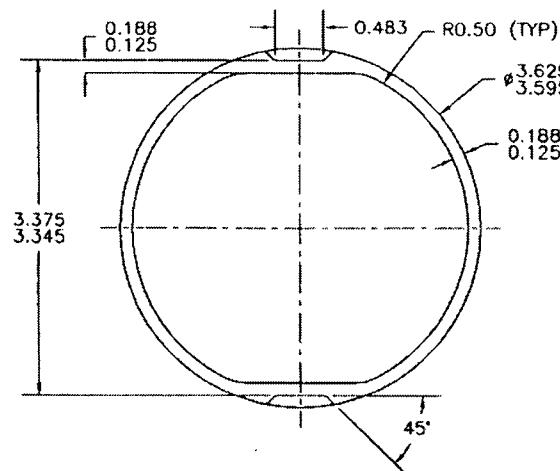
Cap

50513 mf 09-07-29

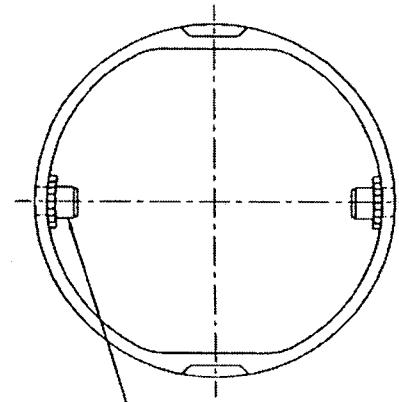
C:\Log\107113  
J10: 50513

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D2855 CASTING DETAIL



D2855 FINISHING DETAIL

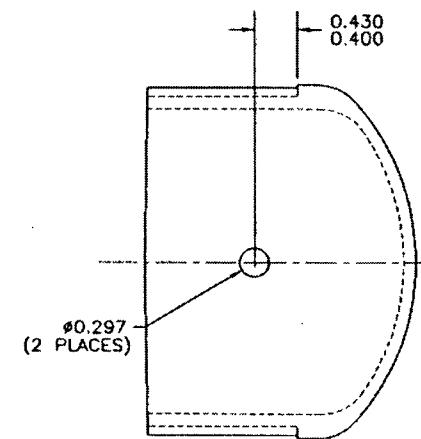
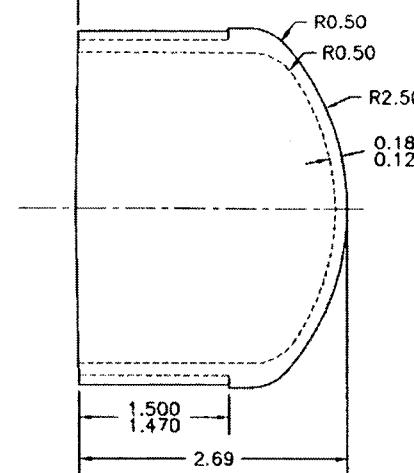


INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR  
ALS7-1032-225, OR AKS4-1032-225) INSERT ON  
INSIDE OF CAP (AFTER POWDER COAT)  
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

1° TAPER



RELEASED  
12.14  
D2855

**DART**

DA COPY IS  
GIVEN

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
JP	KC	DRAWING NO.
DATE		D2855
98.12.12		ITEM CAP
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)
		REV. A
		SHEET 1 OF 1
		SCALE
		NTS

**Aluminum Foundry Ltd**

2225 Chemin St. Francois  
 Dorval, Québec H9P 1K3  
 Tel: (514) 683-9777  
 Fax: (514) 683-0375

**Packing Slip**

Packing Slip No.: 33089  
 Date: Jul 23, 2009  
 Page: 1

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7	DART AEROSPACE 1270 ABERDEEN STREET HAWKSLEY, ONTARIO K6A 1K7
Order No.: 10084	Sold By:
Shipped By: Fedex	Ship Date: Jul 23, 2009
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	52 <i>Rec'd 1/29</i> <i>07/29/09</i>
Comment:			

7CERTIFICAT DE CONFORMITÉ  
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3  
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à Shipped	<b>DART AEROSPACE</b>	A.F. & P.W. Série no./Serial no.
		Packing
	<b>1270 Aberdeen Street</b>	Date: <u>23/07/2009</u> Slip No. <u>33089</u>
	<b>Hawkesbury, ON, K6A 1K7</b>	Votre No. Commande <u>10084</u> Your order No. _____

Ceci est pour certifié que le materiel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificates di détaillante sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
52pcs	D 2855 CAP	Z098046	A356.2	ingot#20090102  <i>S 07/07/09</i>

Analyse  
Analysis (as in ingot)

(Si)	7.17%	(Al)	balance
(Fe)	0.087%		
(Cu)	0.0024%		
(Mn)	0.0017%		
(Mg)	0.37%		
(Zn)	<0.001%		
(Ti)	0.16%		

Donne Yield :	Résistance a la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation :	%
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Pour et au nom de  
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE  
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Coc-100

Dept/Dep :  
Par/Per :

**DART**  
aerospace

Dart Aerospace Ltd.  
 1270 Aberdeen Street  
 Hawkesbury, ON K6A 1K7  
 Tel: 613 632 9577  
 Fax: 613 632 1053

**\*\*\*PO REPRINT\*\*\*****Purchase Order ID PO10084**

**Purchase Order Date** 7/15/09  
**PO Print Date** 7/15/09

**Page Number** 1 of 1

**Order From :** VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.  
 2225 CHEMIN ST. FRANCOIS  
 DORVAL, QC H9P 1K3  
 CA

**FAXED**  
*(Circa 2010)*

<b>Contact Name</b>	<b>Buyer</b>	Chantal Lavoie
<b>Vendor Phone</b>	<b>Requisition Nbr</b>	
<b>Vendor Fax</b>	<b>Tax Resale Nbr</b>	10127-2607
<b>Vendor Account Nbr</b>	<b>Terms</b>	Net 30
	<b>Currency</b>	CAD
	<b>FOB</b>	

**Ship To :** DART AEROSPACE LTD      1270 ABERDEEN  
 HAWKESBURY, ON K6A 1K7  
 CANADA

<b>Line Nbr</b>	<b>Reference Revision ID Vendor Part Number</b>	<b>Description/ Mfg ID</b>	<b>Req Date/ Taxable</b>	<b>Req. Qty/ Unit of Measure</b>	<b>Ship Method</b>	<b>Unit Price</b>	<b>Extended Price</b>
1	D2855P A	Cap	7/24/09 Yes	50.00 Each	FedEx Economy	\$16.9000	\$845.00
		<b>Special Inst:</b>	AS PER DWG D2855 REV. A BS0513				
			<b>PO Total:</b> \$845.00				

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Rush order!

CD  
U

No substitution or deviation without consent.  
 Certificate of Conformity or Material Certification required when applicable

Change Nbr: 2

Change Date: 7/15/09